

Work Order ID 149497

Monday, July 25, 2016 10:53:24 AM

149497

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Item ID: D206-667-201

Revision ID:

Item Name: Aft Crosstube - High 206 A/B

Start Date: 7/25/2016 Start Qty: 1.00

Required Date: 7/29/2016 Req'd Qty: 1.00

Reference: touch up, return to stock

Approvals: Process Plan:

QC:

Date:

Date:

Accept

Tooling:

SPC (Y/N):

N900040100

Cust Item ID:

Customer:

Setup Start ***NS1***Stop ***NS2***Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

Draw Nbr

Revision Nbr

D206-667-241

Rev C (DEO)

DSI 9471

Rev A

100

Document Control

0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels as per PPP D206-667-201 CHG004

DAS
21
9-89

DEC 05 2016

210

SprayPaint

0.00

210

SprayPaint

Memo

0.11

Spray Painting

PULL FROM TRIAL FIT:
1 X D206-667-201 B140408

TOUCH UP A/R

PAINT: 135621

MP
7.11.16

M2 / 16-06-1

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
3/4/11 PS -245								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER :							
Misidentified ☐	☐ Past Due								

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Reference: touch up, return to stock

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

220

QC14- Inspect Spray Paint

0.00

220

QC

Quality Control

Memo

0.00

Wrap in plastic bag to protect from scratches

VERIFY BY AD BATCH # TO MATCH W/OVERIFY BY AD PART # TO MATCH
W/O _____

① 16-11-14 AD.

250

Pick Kit

0.00

250

Packaging

Memo

0.00

Packaging

ENSURE ORIGINAL KIT IS IN BOX

DART aerospace				1270 ABERDEEN ST. HAWKESBURY ON. CANADA K6A 1K7 TEL: 1-813-632-5200 www.dartaero.com	
PATENT	N/A			CHG	CHG004
P/N	D206-667-201			STC	SH01-5
DESC.	Crosstube Aft High			STC	SR01304NY
LOT	B140408			STC	
MODEL	Bell 206A/B			STC	
TC APPROVAL # 09-89		MADE IN CANADA		02729-4	

DQA: _____ Date: _____



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Misidentified ☐	Past Due ☐																																																																

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Required Date: 7/29/2016 Req'd Qty: 1.00

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Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

260

QC4- 100% Inspect kits for completeness

0.00

260

QC

Quality Control

Memo

VERIFY BY 9-89 BATCH # TO MATCH W/OVERIFY BY _____ PART # TO MATCH
W/O _____DAS
27
9-89DAS
27
9-89

DEC 05 2016

270

Packaging

0.00

270

Packaging

Packaging

Memo

REPACKAGE USING NEW B/N
NEW LAB ELS REQ'DIdentify and pack for shipping as per PPPD206-667-201
Location : FG103DAS
27
9-89

DEC 05 2016

280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Quality Control

Memo

0.02

16/12/6

DAS
21
9-89

DEC 06 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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Description Work Order Deviation				Disposition					
								Completed By	
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Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
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Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

Picklist Print

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Work Order ID: 149497

149497

Parent Item: D206-667-201

D206-667-201

Parent Item Name: Aft Crosstube - High 206 A/B

Start Date: 7/25/2016

Required Date: 7/29/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
11.08.08 PER ECN 11-615 DD VERF:EC

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D206-667-201		Manufactured	No				Each	5.0000		1			
D206-667-201									**				
Aft Crosstube - High 206 A/B													

Location

Loc Qty

Loc Code

FG

1

120858

1

FG103

4

120857

1

140406

1

140407

1

140409

1

BH0408

①

BT

16-08-17

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Linda Lacelle

From: Steven Drouin
Sent: Thursday, July 21, 2016 2:23 PM
To: Linda Lacelle
Subject: w/o for touch up paint

Hi Linda

I will need a w/o for paint touch up on these parts

D2661-2 x 2 B129615, B121702 — 149489
D2661-1 x 2 B141282 — 149490
D2662-1 X 2 B124309 — 149491
D2662-2 x 2 B129616 — 149492

D2666-2 x 2 B121591 B113167 — 149493
D2666-1 x 1 B109550 — 149494
D2665-1 x 1 B120551 — 149495
D2665-2 x 2 B136230 — 149496

And Aft Crosstube

D206-667-201 B140408 — 149497

Steven Drouin

Dart Aerospace

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Special Projects Coordinator
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